

Date: Monday, 02/03/2009 11:25:50 AM  
User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 46197  
Estimate Number : 12942  
P.O. Number :  
This Issue : 02/03/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : // Type : SMALL /MED FAB  
Previous Run : 45195  
Written By :  
Checked & Approved By : JUD 09-03-02  
Comment : Est Rev :A New Issue 07-01-22 EC

Drawing Name : DOOR DOUBLER

Part Number : D3594044  
Drawing Number : D3594 REV B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 16/03/2009

Qty: 8 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 4.2840 sf(s)

6061-T6 .080 Sheet

Batch: 111003

ml 09 03 06 (8)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: BProg Rev: B

2-Deburr if necessary

ml 09 03 06 (8)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 06 (8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Sc 02/03/06 (8-4)

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

p10  
8/30/03/09 (8)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 46197

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/09

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD/BR

09/03/09

(17)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

/

SB 09/03/09 (7)

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Anchor nuts

BATCH: ~~51167235~~ (6) (17)

M111310

EF 09/04/01

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Rivet

BATCH: M15541

EF 09/04/01

11.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

EF 09/04/01 (2)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S. 09/04/01 (2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 248B

9/1/02

54



Job Number: 46197

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*  
09-04-02

DART AEROSPACE LTD		Work Order:	4619
Description: Floor Doubler, RH		Part Number:	D3594-4
Inspection Dwg: D3594 Rev: A		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

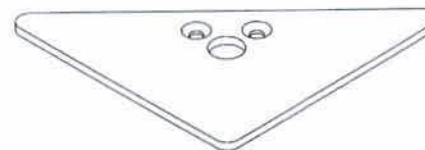
[illegible]

Measured by:	M. M.	Audited by:	S	Prototype Approval:	N/A
Date:	09/03/06	Date:	02/03/06	Date:	N/A

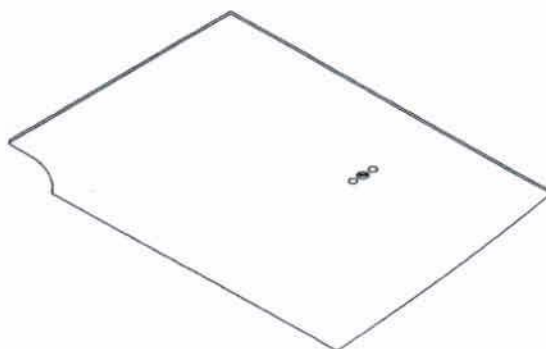
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-044	KJ/JLM	<i>[Signature]</i>



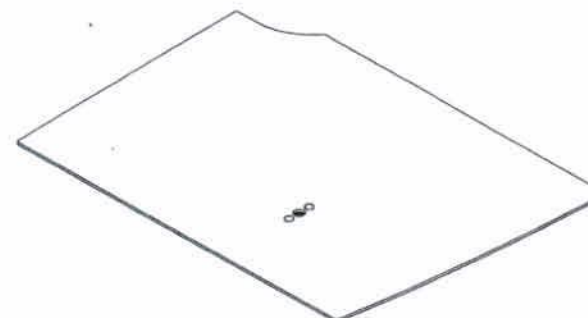
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



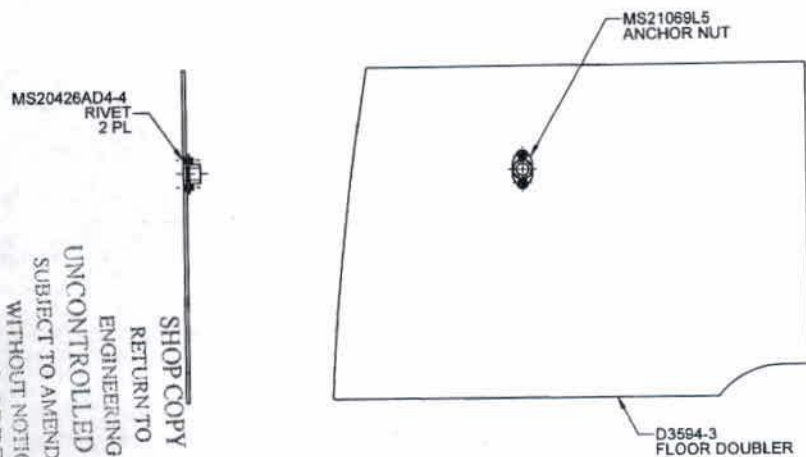
D3594-044 FLOOR DOUBLER ASSEMBLY

RELEASED  
08.05.14

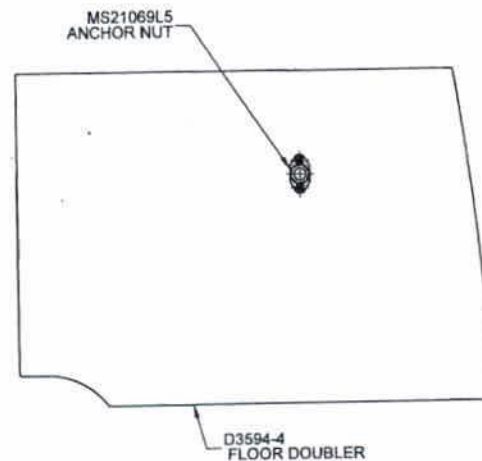
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B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



**D3594-043 FLOOR DOUBLER ASSEMBLY**



**D3594-044 FLOOR DOUBLER ASSEMBLY**

**NOTES:**

- 1) MATERIAL: -3 & -4  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 3 OF 4
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